

Date: Wednesday, 6/27/2007 3:26:01 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HOUSING	
Job Number : 33240		
Estimate Number : 11870		
P.O. Number : <i>N/A</i>	Part Number : D22071	
This Issue : 6/27/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2207 REV C <i>PRELIM</i>	
Prsht Rev. : NC	Project Number : <i>N/A</i>	
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : C <i>PRELIM</i>	
Previous Run : <i>N/A</i>	Material : <i>N/A</i>	
Written By : <i>[Signature]</i>	Due Date : 7/4/2007	Qty: 10 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.06.28		
Comment : Est. A 01.03.08 New Issue		

Additional Product

POSITIVE RECALL

EFFECTIVE *07.06.28* AUTH *[Signature]*RELEASED *07.06.28* DATE *[Signature]*

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S063 6061-T6 .063 Sheet



Comment: Qty.: 0.4375 sf(s)/Unit Total : 4.3754 sf(s)

6061-T6 .063 Sheet

5052-H32 or 6061-T6 - .063" Thick

Batch *M100285**07-06-28*

2.0 SHEAR SHEAR



Comment: SHEAR

Shear blanks: 4.200" x 14.00" +.000"/-.030"

Grain along 14.00"

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA031

Deburr

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE


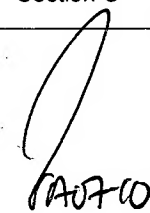
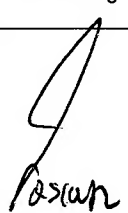

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 01/01/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/09	6	1 piece was out of tolerance	 07/02/09	Scrap & destroy	SB 07/02/09	 07/02/09	 07/02/09	 07/02/09

NOTE: Date & initial all entries

Date: Wednesday, 6/27/2007 3:26:01 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING

Job Number: 33240

Part Number: D22071

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend as per dwg D2207

SP 07/07/09 (9)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 07/07/10 (9)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

SP 07/07/10 (9)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(9)

Comment: FINAL INSPECTION/W/O RELEASE

SP 07/07/10

Job Completion



POSITIVE RECORD

EFFECTIVE

1/1/10

AUTH

07/07/10

RELEASED

1/1/10

DATE

07.07.10

u 07-07-11

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

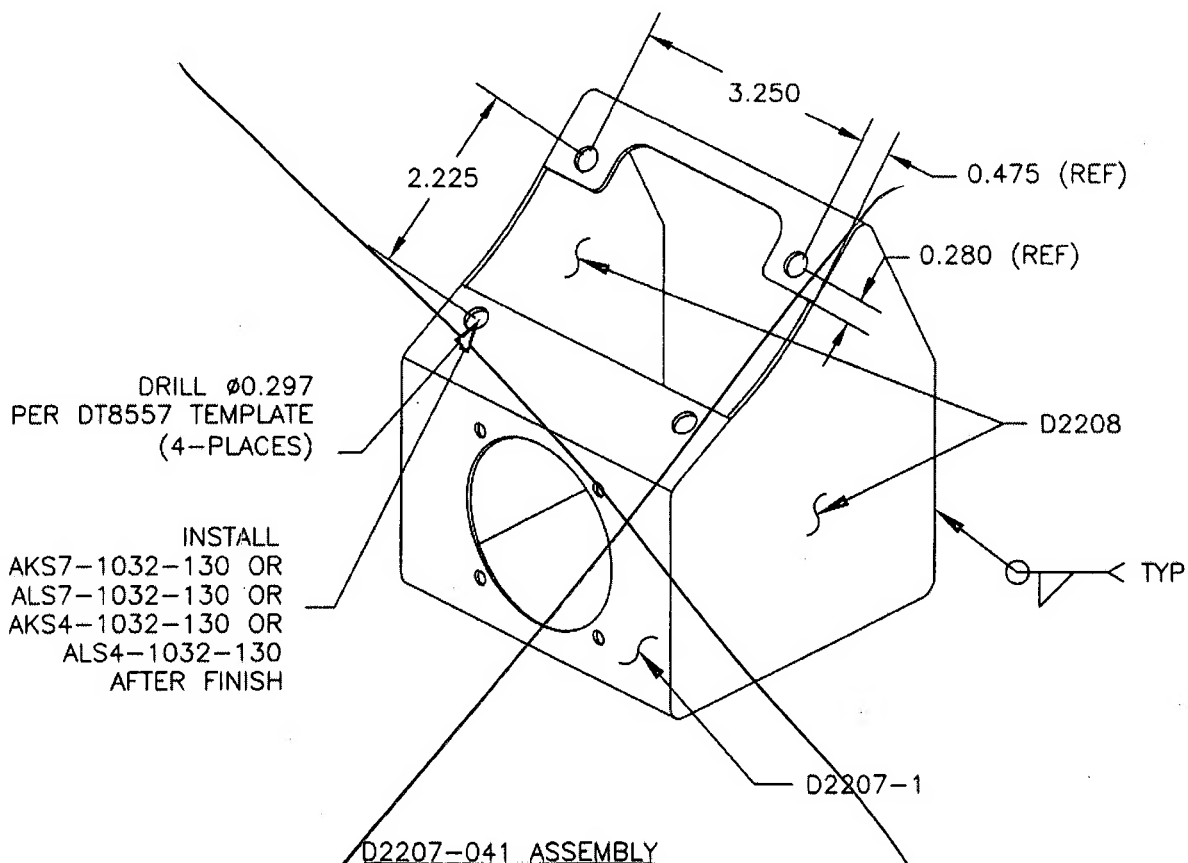






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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2207	REV. B SHEET 1 OF 2
DATE 01.02.23	TITLE HOUSING		SCALE 1:2
A	94.09.01	NEW ISSUE	
B	01.02.23	REDRAWN	

RELEASED  
01.02.27 #



NOTE:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH. CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT CLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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WORK ORDER  
NO. 33240

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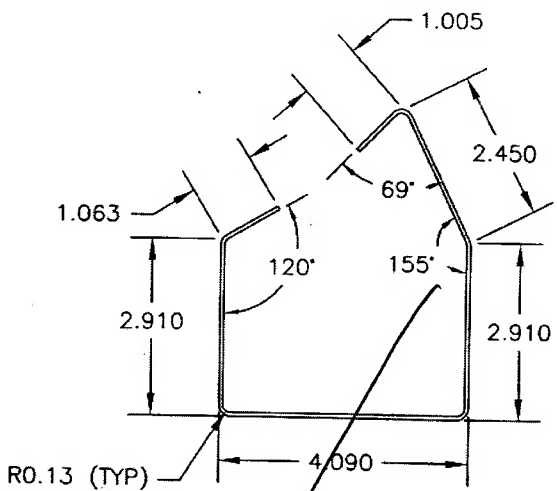
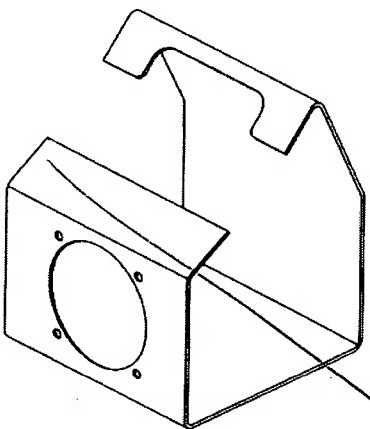




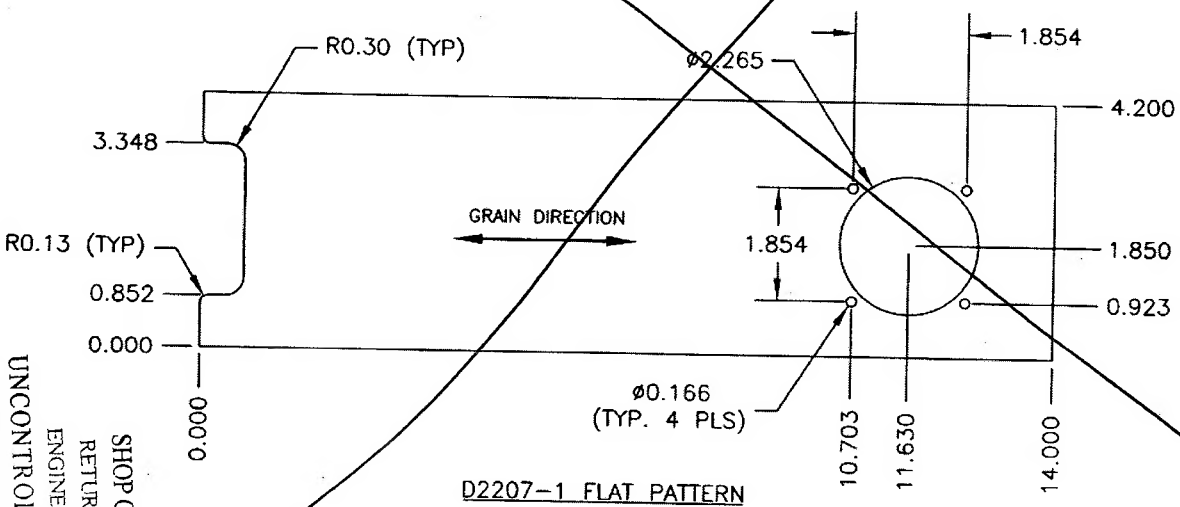
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9.02.27

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CHECKED		APPROVED		DRAWING NO.	D2207
DATE	01.02.23			TITLE	HOUSING
				SCALE	1:3



D2207-1 BENDING DETAIL



D2207-1 FLAT PATTERN

MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) ALUMINUM 0.063 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. 33240

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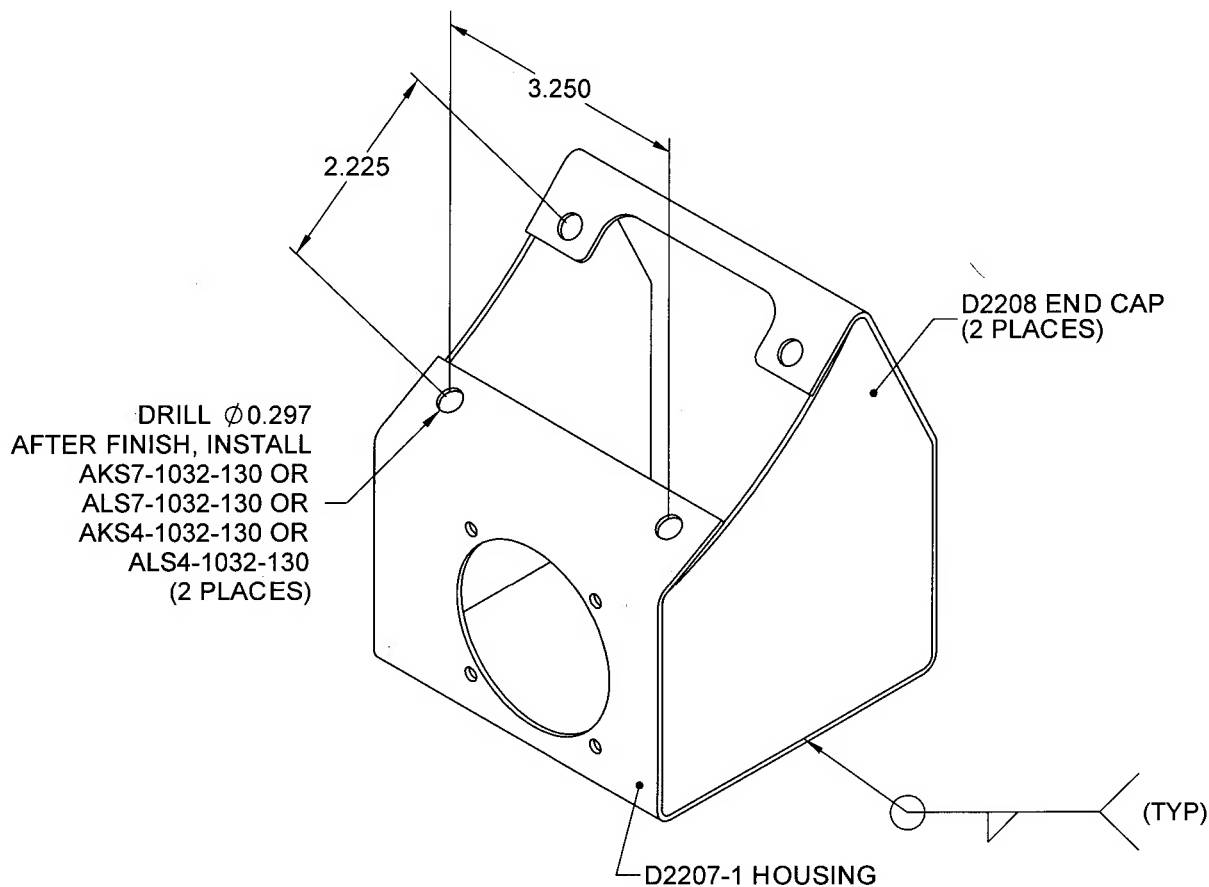
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**PRELIMINARY ISSUE**

07.06.28

DESIGN PH	DRAWN BY JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED	DRAWING NO. D2207	REV. C SHEET 1 OF 2
DATE 07.06.28		TITLE HOUSING	SCALE 1:2
REV	DATE	DESCRIPTION	
A	94.09.01	NEW ISSUE	
B	01.02.23	REDRAWN	
C	07.06.28	REDESIGN	



**D2207-041 FLAT PATTERN**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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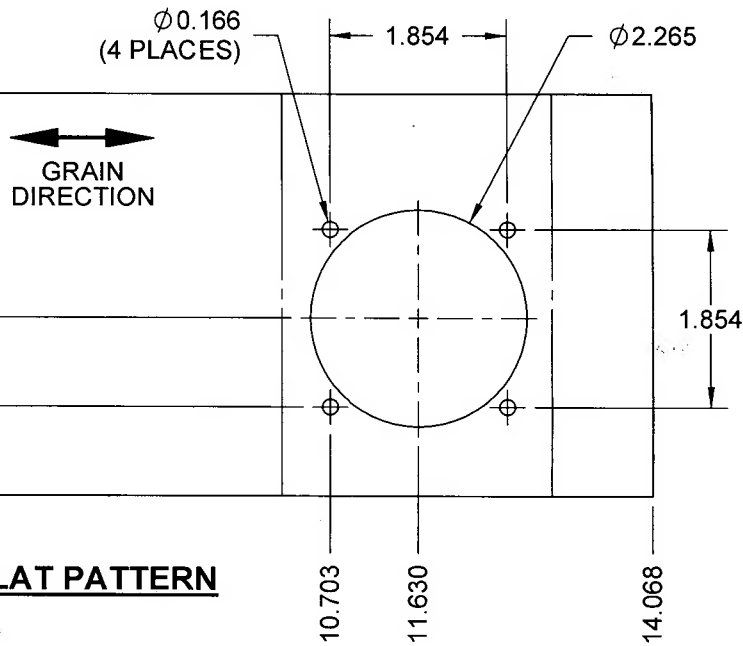
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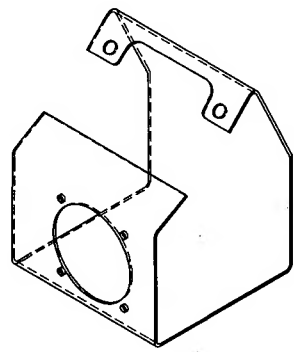
**PRELIMINARY ISSUE**

01.06.28

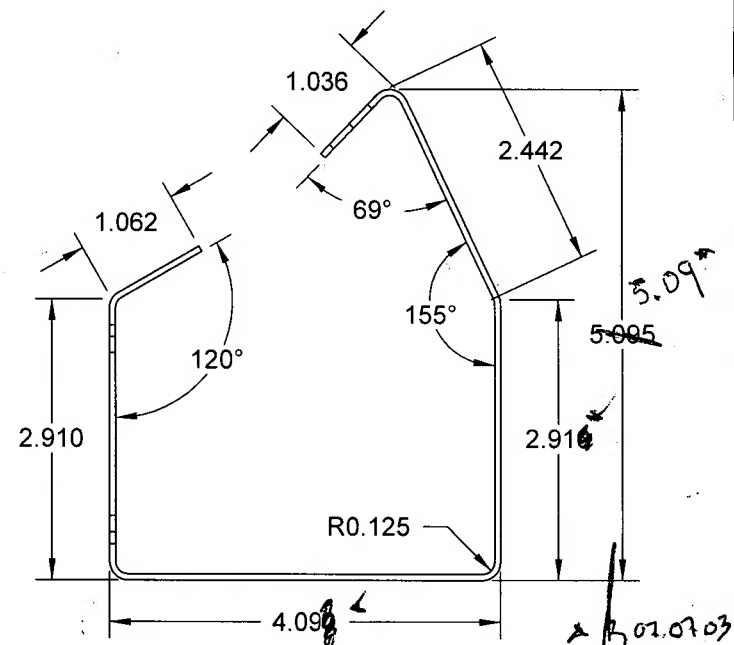
DESIGN	DRAWN BY	DART AEROSPACE LTD
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DATE	DRAWING NO.	REV. C
07.06.28	D2207	SHEET 2 OF 2
	TITLE	SCALE
	HOUSING	1:2



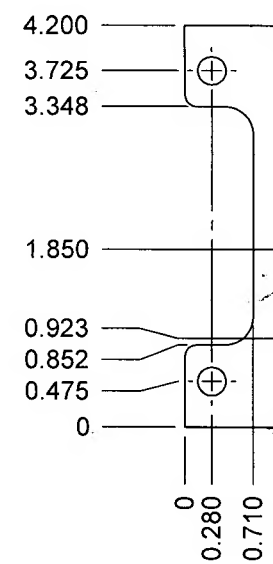
**D2207-1F FLAT PATTERN**



**ISOMETRIC VIEW**  
(SCALE 1 : 4)



**D2207-1 BENDING DETAIL**



**D2207-1 HOUSING**

**NOTES:**

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/8 OR AMS 4016  
(REF. DART SPEC. M5052H32S.063) OR  
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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